

Date: Friday, 2/23/2007 1:47:50 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD TUBE ASSEMBLY
Job Number	: 30926		
Estimate Number	: 10467		
P.O. Number	: N/A	Part Number	: D3391021
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: D3391 UNDER REVIEW 07.02.26 <i>EL</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: <i>EF</i>
Previous Run	: 30925	Material	: N/A
Written By	:	Due Date	: 3/21/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>AD 07.02.26</i>		
Comment	: Est. A 05.09.13 New issue KJ/JLM		
	: Est. B 06.02.10 Dwg rev.D ecn 773 EC		
	: Est. C 06.05.02 Added inspections EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6013047	SKIDTUBE MAT'L
-----	----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description	Batch
1	D6013-047	Extrusion	<i>b 26547</i>

JB 7-3-22

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

JB 7-3-8

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: No bender

Bend as per Dwg D3391 Using Bend Prog 3391021

EL 7-3-28

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

BC 07.04.02

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. *AA* & Dwg D3391 Rev. *E*

Identify as D3391-1

2-Deburr

*BC 07.04.02**CU*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:47:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 30926

Part Number: D3391021

Job Number:



Seq. #

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RG 07-04-02

①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L. 07/04/02

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill and c/sink float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Drill wearplate holes as per Dwg D3391 Using Dt8217 & DT8878

6--Deburr

> NIA check new w/o's

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

For 04-20 @

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L.

07/04/02

①

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

For 04-23 @

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.L.

07-04-23

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
7-4-4	8	Wearplate holes drilled on 3391-023 W/O. changes have been made to new order.	DP	7-4-4		<i>[Signature]</i> 07/01/20	<i>[Signature]</i> 07/01/20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			<i>[Initial]</i>					

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:47:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 30926

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.L. 07/04/23

14.0

NAS1330C3KB166

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Rivnut

Pick:

Qty

Part Number

Description

Batch

14

NAS1330C3KB166

Insert

M103278

*

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

FL 07/04/27 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.05.01 ①

17.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

B31346

TURN OVER →

18.0

AN3C4A

BOLT



*

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

10

AN3C4A

Bolt

M103585 ⑧
M103691 ② *

19.0

NAS1515H3L

WASHER



①

Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

M.L. 07/05/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.05.03	17.0	PER D3391 Rev F D3564-13 Wearplate (1) <u>B31398</u> D3566-13 Gasket (1) <u>B31348</u>	RL 07.05.03				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/05/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 1:47:50 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 30926

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

4

NAS1515H3L

Washer

M 103641

20.0

AN960C10L

washer



Comment: Qty.: 40000 Each(s)/Unit Total: 40000 Each(s)
washer 10 PH 07-05-03 10

M 104215

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install tow Cap as per Dwg D3391
Identify as D3391-021

M.A

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect thread of each insert using DT8821

7-05-7

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

PPP 031709

7/5/11 Sd

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
2/23/07/14

Job Completion



U 07-05-14

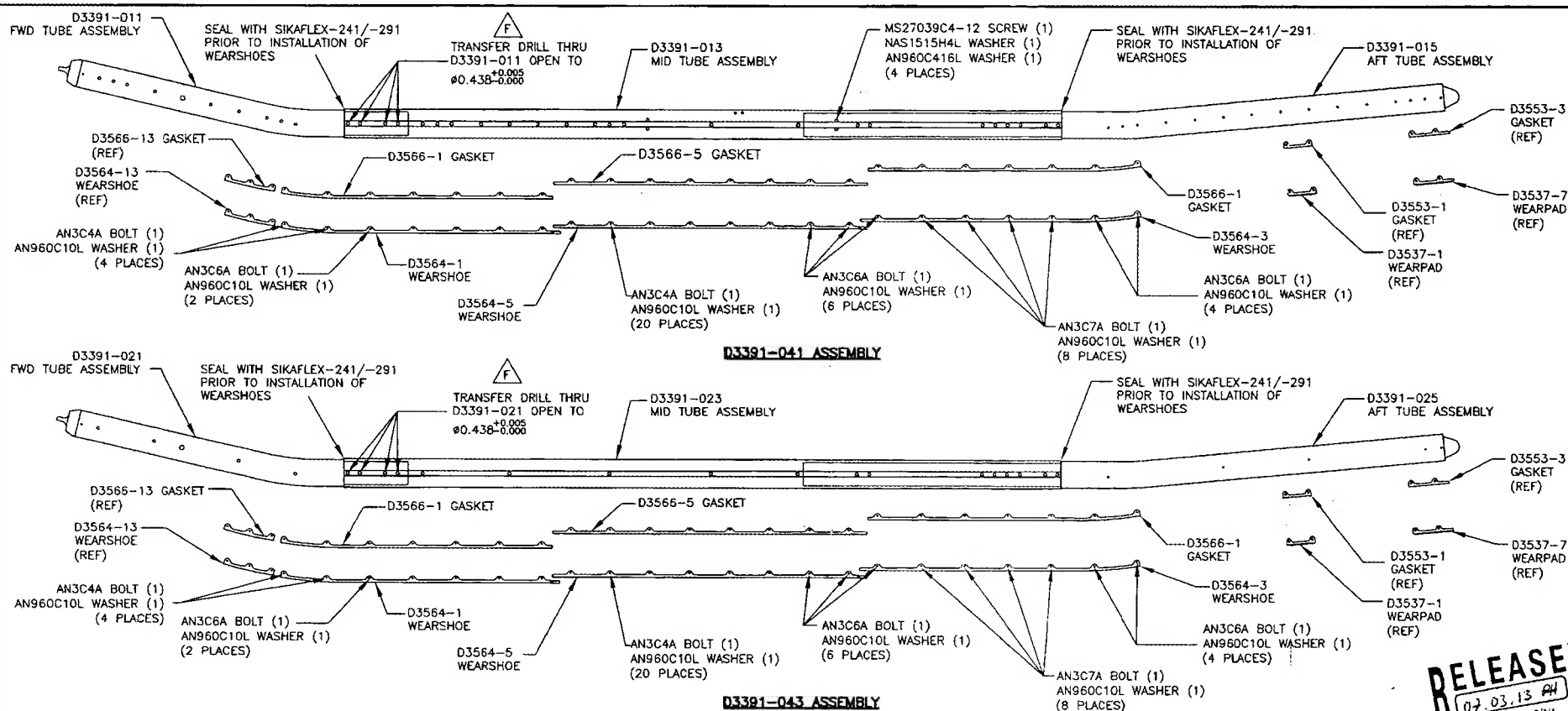
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	Float Skidtube Assembly
		D3391-043	Float Skidtube Assembly
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C/SINK Ø0.391/Ø0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

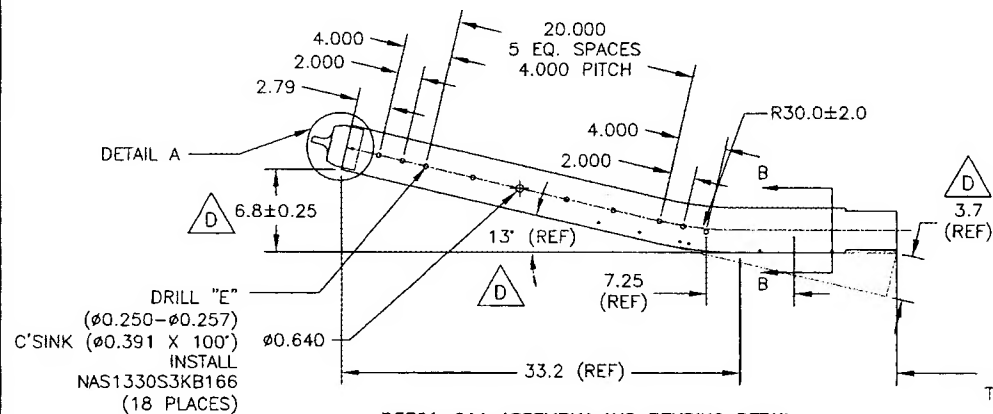
COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

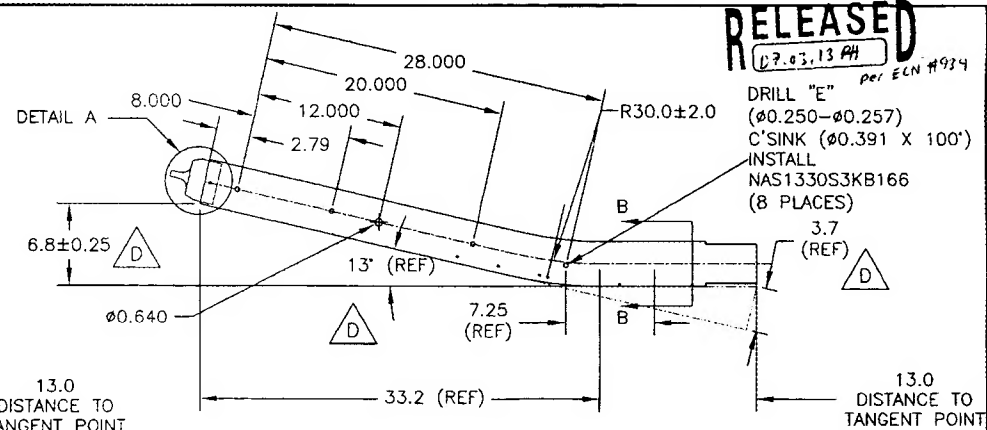
F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3391
DATE	TITLE	REV. F SHEET 1 OF 5 SCALE 412 FLOAT SKIDTUBE NTS
07.01.18		

RELEASED
07.03.13 RH
PAR ECU #934

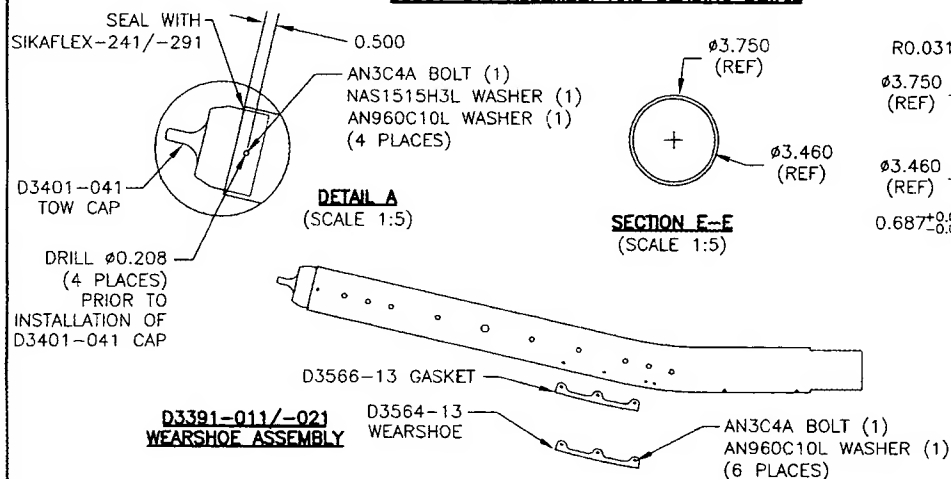
RELEASED
 07.03.13 PH per ECN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



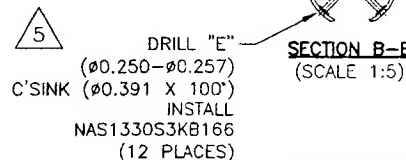
D3391-021 ASSEMBLY AND BENDING DETAIL



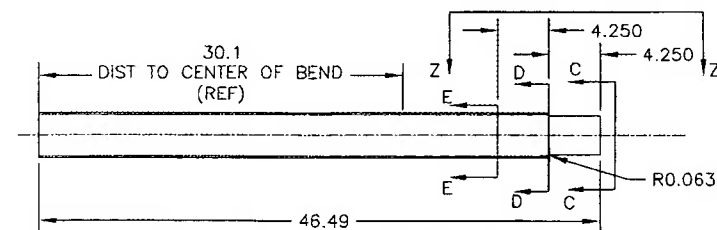
D3391-011/-021 WEARSHOE ASSEMBLY

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

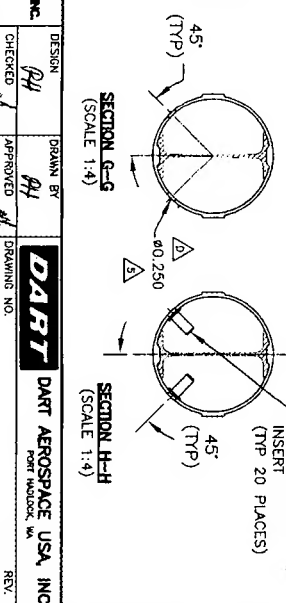
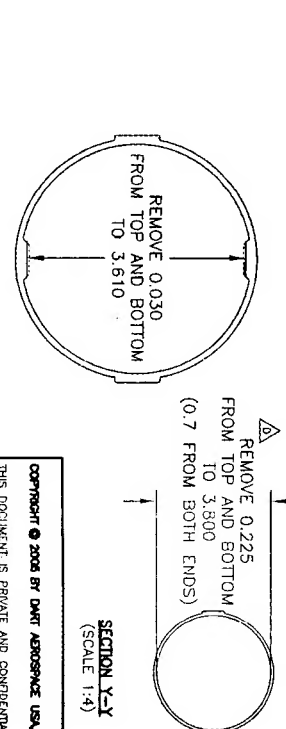
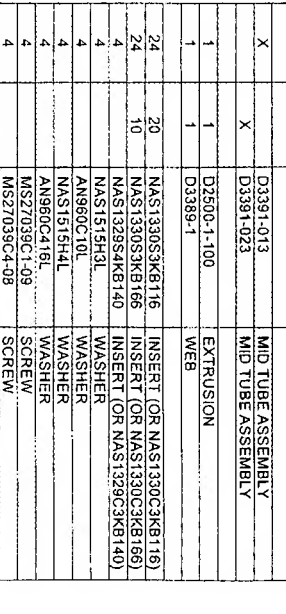
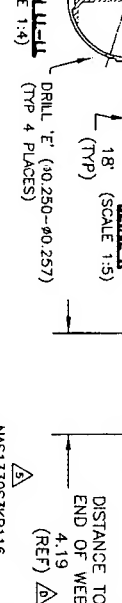
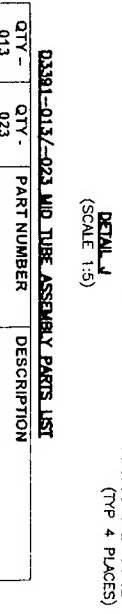
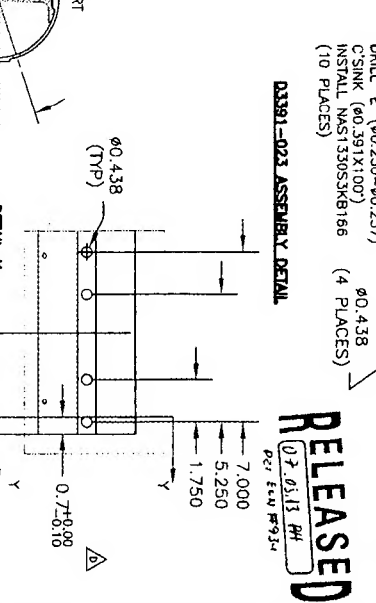
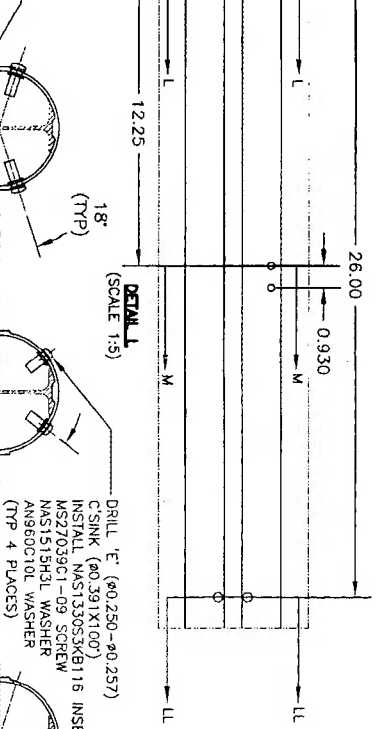
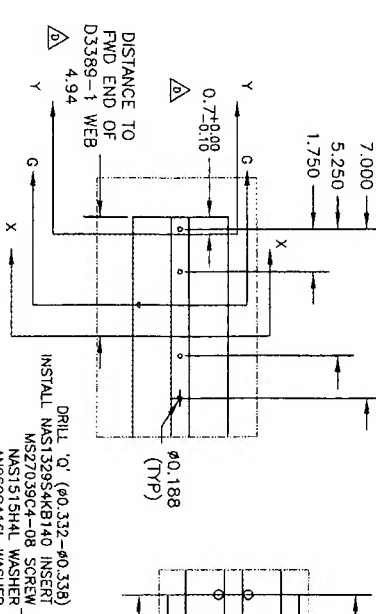
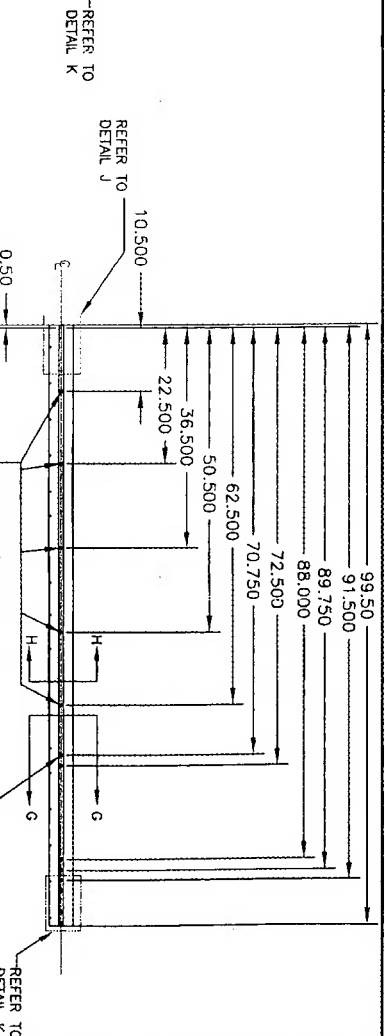
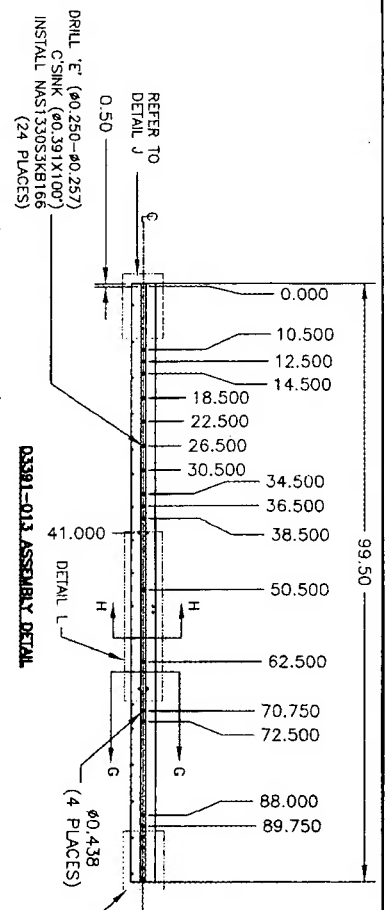


SECTION B-B (SCALE 1:5)



D3391-1 DRILLING AND CUTTING DETAIL (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.		DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED A	APPROVED A	DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.				DRAWING NO. D3391 SHEET 2 OF 5 SCALE 1:10



1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SWAPLEX-241/-291 PER QSI 015

SECTION X-X
(SCALE 1:2)

SECTION M-M
(SCALE 1:4)

SECTION Y-Y
(SCALE 1:4)

SECTION G-G
(SCALE 1:4)

SECTION H-H
(SCALE 1:4)

Copyright © 2004 by DART Aerospace USA, Inc.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED, COPIED, OR DISSEMINATED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART Aerospace USA, Inc.

DESIGN: **PA** DRAWN BY: **PA**

CHECKED: **PA** APPROVED: **PA**

DATE: 07.01.18

DRAWING NO.: D3391

TITLE: 412 FLOAT SKIDTUBE

REV. F

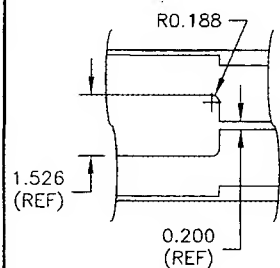
SHEET 3 OF 5

SCALE: 1:20

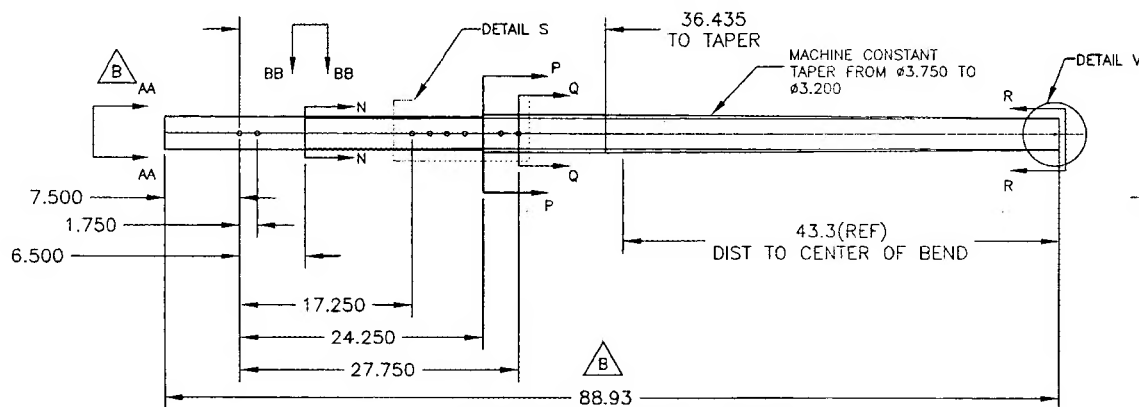
DART AEROSPACE USA, INC.

PORTLAND, ME

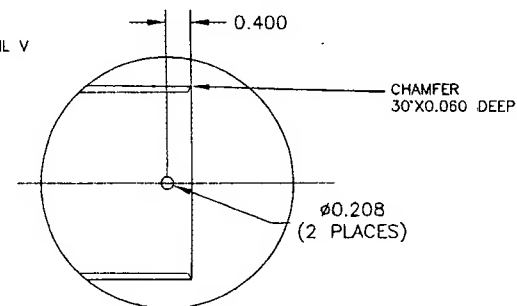
RELEASED
07.05.13
Per FAR 93.4



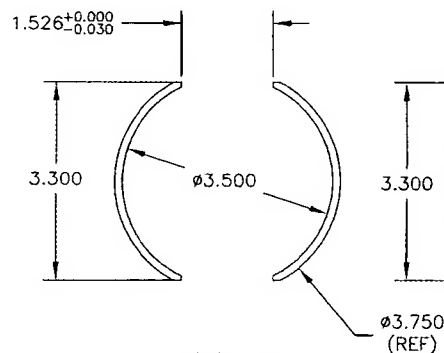
VIEW BB-BB
(SCALE 1:3)



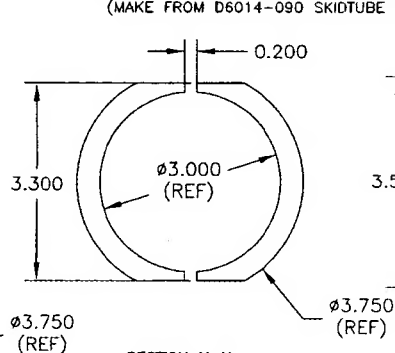
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



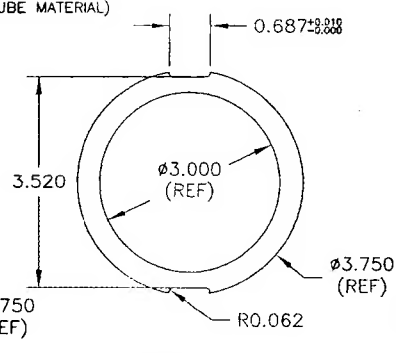
DETAIL V
(SCALE 1:2)



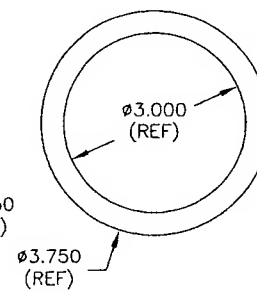
SECTION AA-AA
(SCALE 1:2)



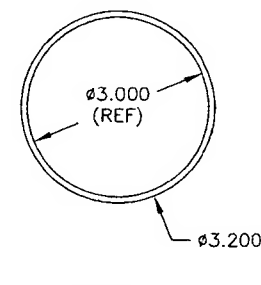
SECTION N-N
(SCALE 1:2)



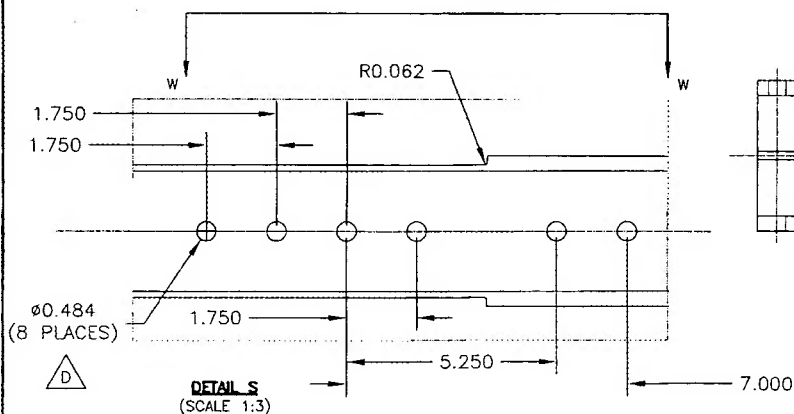
SECTION P-P
(SCALE 1:2)



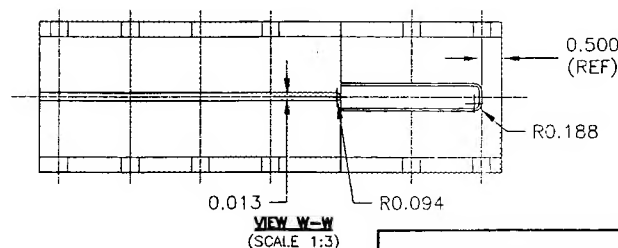
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

RELEASED
07 03 13 PH
per ELN #934

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED A	APPROVED A	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

DART AEROSPACE LTD	Work Order:	31308
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: EF 02.05.20		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

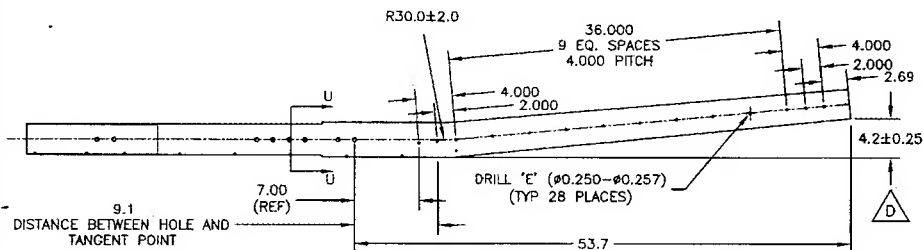
[illegible]

Measured by:	BC
Date:	07.04.02

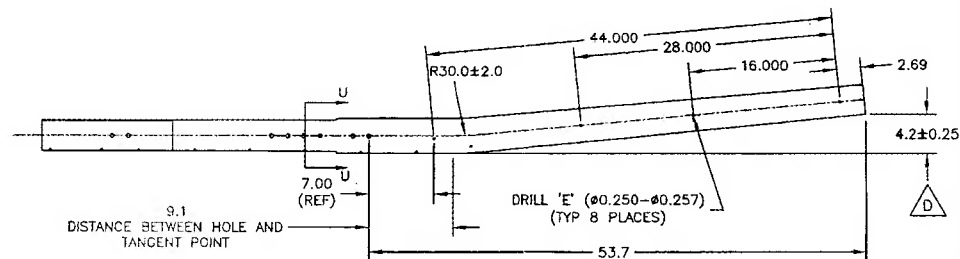
Audited by:	J.L.
Date:	07/04/02

Prototype Approval:	N/A
Date:	N/A

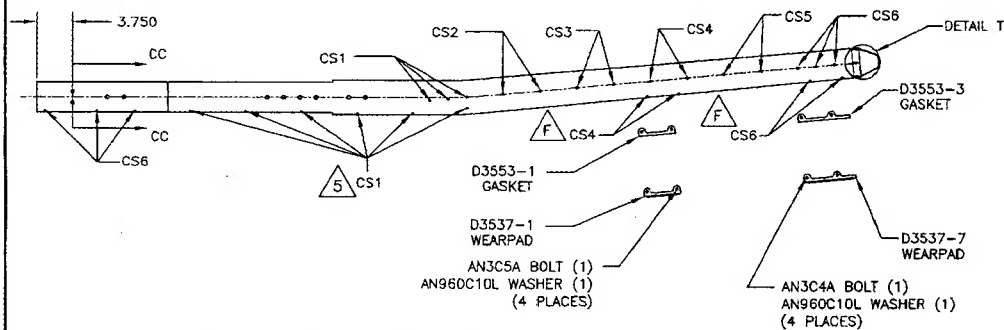
Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	



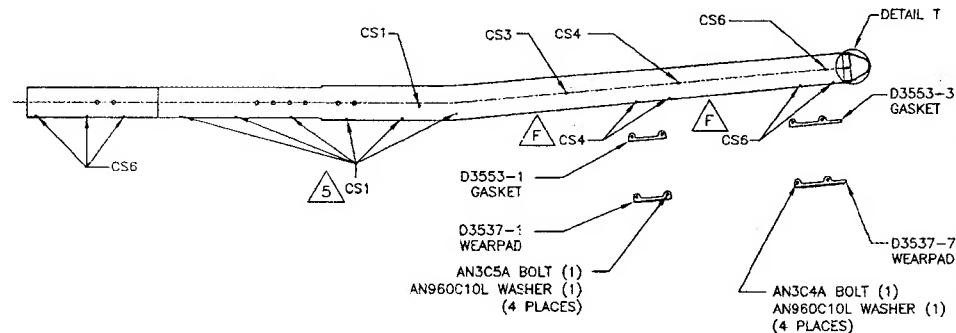
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



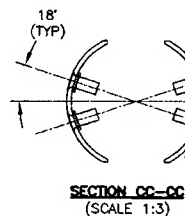
D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)



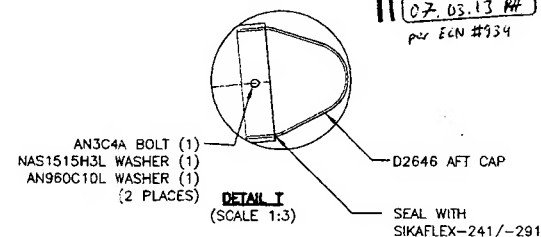
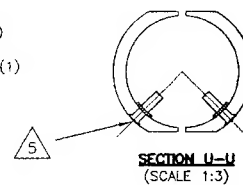
D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-080	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4	2	NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4	2	NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' (Ø0.332-Ø0.338)
C'SINK (Ø0.529X100')
NAS1330S4KB151 INSERT (1)
(4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	PIN
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

COPYRIGHT © 2006 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DESIGN	D4	DRAWN BY	D4	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	H	APPROVED	H	DRAWING NO. D3391
DATE	07.01.18	TITLE	412 FLOAT SKIDTUBE	REV. F SHEET 5 OF 5 SCALE 1:12

RELEASED
07.03.13 R4
per EGN #934